

# Work Order ID 50490

July 10, 2009 2:40:14 PM



Page 1

Item ID: D3958-1KIV

Accept



Setup Start



Revision ID: A-PROTO

Stop



Item Name: Panel

Start Date: 07/13/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 07/17/2009 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: MF

Date: 09-07-10 Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



| Sequence ID/<br>Work Center ID | Operation<br>Description | Set Up/<br>Run Hours | Draw<br>Number | Draw<br>Rev. | Plan<br>Code | Accept<br>Qty | Reject<br>Qty | Reject<br>Number | Insp.<br>Stamp |
|--------------------------------|--------------------------|----------------------|----------------|--------------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|----------------|--------------|--------------|---------------|---------------|------------------|----------------|

Draw Nbr

Revision Nbr

D3958

A-PROTO 09.06.10

100

0.00



HandThermo

Memo

0.00

Hand Finishing Thermoforming

1-Cut Sheet to required Blank size

BB 09/07/15 (X1)  
M109703

110

0.00





Thermoform

Memo

0.00

Thermoforming Machine

1-Machine Set-Up  
2-Pre-heat Tool to required temp.  
3-Thermoform as per Dwg and Folio #FTA050 using tool DT9318  
Dwg Rev:   
Folio Rev: 

BB 09/07/15 (X1)



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Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



| Sequence ID/<br>Work Center ID | Operation<br>Description                               | Set Up/<br>Run Hours | Draw<br>Number | Draw<br>Rev. | Plan<br>Code | Accept<br>Qty | Reject<br>Qty | Reject<br>Number | Insp.<br>Stamp |
|--------------------------------|--|----------------------|----------------|--------------|--------------|---------------|---------------|------------------|----------------|
| 120                            | QC2- Inspect parts off machine FAI/FAIB                | 0.00                 |                |              |              |               |               |                  |                |
|                                |  |                      |                |              |              |               |               |                  |                |
| QC                             | Memo   | 0.00                 |                |              |              |               |               |                  |                |
| Quality Control                | Visually inspect part for proper formation and texture |                      |                |              |              |               |               |                  |                |
|                                |  |                      |                |              |              |               |               |                  |                |
| 130                            | QC8- Inspect parts - second check                      | 0.00                 |                |              |              |               |               |                  |                |
|                                |  |                      |                |              |              |               |               |                  |                |
| QC                             | Memo   | 0.00                 |                |              |              |               |               |                  |                |
| Quality Control                |  |                      |                |              |              |               |               |                  |                |
|                                |  |                      |                |              |              |               |               |                  |                |
| 140                            |  | 0.00                 |                |              |              |               |               |                  |                |
|                                |  |                      |                |              |              |               |               |                  |                |
| Hand Thermo                    | Memo   | 0.00                 |                |              |              |               |               |                  |                |
| Hand Finishing Thermoforming   | 1-Trim to finished dimensions as per Dwg               |                      |                |              |              |               |               |                  |                |

BB 09/07/15 (X1)

Dr. 09/07/15 (X1)

Dr. 09/07/15 (X1)

Dr. 09/07/15



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Item ID: D3958-1KIV

Accept



Setup Start



Revision ID: A-PROTO

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Item Name: Panel

Start Date: 07/13/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 07/17/2009 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



| Sequence ID/<br>Work Center ID | Operation<br>Description                      | Set Up/<br>Run Hours | Draw<br>Number | Draw<br>Rev.            | Plan<br>Code | Accept<br>Qty | Reject<br>Qty | Reject<br>Number | Insp.<br>Stamp |
|--------------------------------|---|----------------------|----------------|-------------------------|--------------|---------------|---------------|------------------|----------------|
| 150<br>                        | QC2- Inspect parts off machine FAI/FAIB       | 0.00                 |                |                         |              |               |               |                  |                |
| QC<br>Quality Control          | Memo<br>Complete FAI document                 | 0.00                 |                | 07.09/07/15 (X1)        |              |               |               |                  |                |
| 160<br>                        | QC5- Inspect part completeness to step on W/O | 0.00                 |                | 09.07.20                |              |               |               |                  |                |
| QC<br>Quality Control          | Memo  | 0.00                 |                |                         |              |               |               |                  |                |
| 170<br>                        | Identify as per dwg & Stock Location: _____   | 0.00                 |                |                         |              |               |               |                  |                |
| Packaging<br>Packaging         | Memo  | 0.00                 |                | FOR ENG'G TEST 09.07.20 |              |               |               |                  |                |

ENGINEERING  
APPROVAL

ENCLOSURE  
A

**Work Order ID 50490**

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Item ID: D3958-1KIV

Accept

Revision ID: A-PROTO

Item Name: Panel

Start Date: 07/13/2009 Start Qty: 1.00

Required Date: 07/17/2009 Req'd Qty: 1.00

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw Draw Plan Accept Reject Reject Insp.  
Number Rev. Code Qty Qty Number Stamp

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

*Handwritten:* 09-07-20 Prototype

*Handwritten:* 23-07-09





# Picklist Print

Page 1

July 10, 2009 2:40:14 PM

Work Order ID: 50490

Parent Item: D3958-1KIVRevA-PROTO

Parent Item Name: Panel

Start Date: 07/13/2009

Required Date: 07/17/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

| Component Item ID/<br>Item Name | Replacement<br>Item ID | Mfg/<br>Purch | Bin<br>Item | Primary<br>Location | Last<br>Location | Route<br>Seq ID | Unit of<br>Measure | Qty on<br>Hand | Remaining<br>Qty To Pick | Qty<br>Issued | Date<br>Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|--------------------------|---------------|----------------|--------|
| MKYD6185S.080-P3-<br>62015      |                        | Purchased     | No          |                     |                  | 100             | sf                 | 894.5038       | 2.4791                   |               |                |        |



6185 KYDEX .080"

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

894.5037653

109703

894.503765

M109703



|                                       |  |              |              |
|---------------------------------------|--|--------------|--------------|
| DART AEROSPACE LTD                    |  | Work Order:  | 50490        |
| Description:                          |  | Part Number: | D 3958-1 K14 |
| Inspection Dwg: D 3958-1 Rev: A PROTO |  | Page 1 of 1  |              |

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

### THERMOFORMING SECTION

| Description   | Accept | Reject | Method of Inspection | Comments |
|---|--------|--------|----------------------|----------|
| Inside Radii less than _____"                                   | ✓      |        |                      |          |
| Shape Definition  | ✓      |        |                      |          |
| Texture Retention   | ✓      |        |                      |          |
| Material imperfections such as bumps, cracks, voids, scratching | ✓      |        |                      |          |
|   |        |        |                      |          |
|   |        |        |                      |          |
|   |        |        |                      |          |
|   |        |        |                      |          |

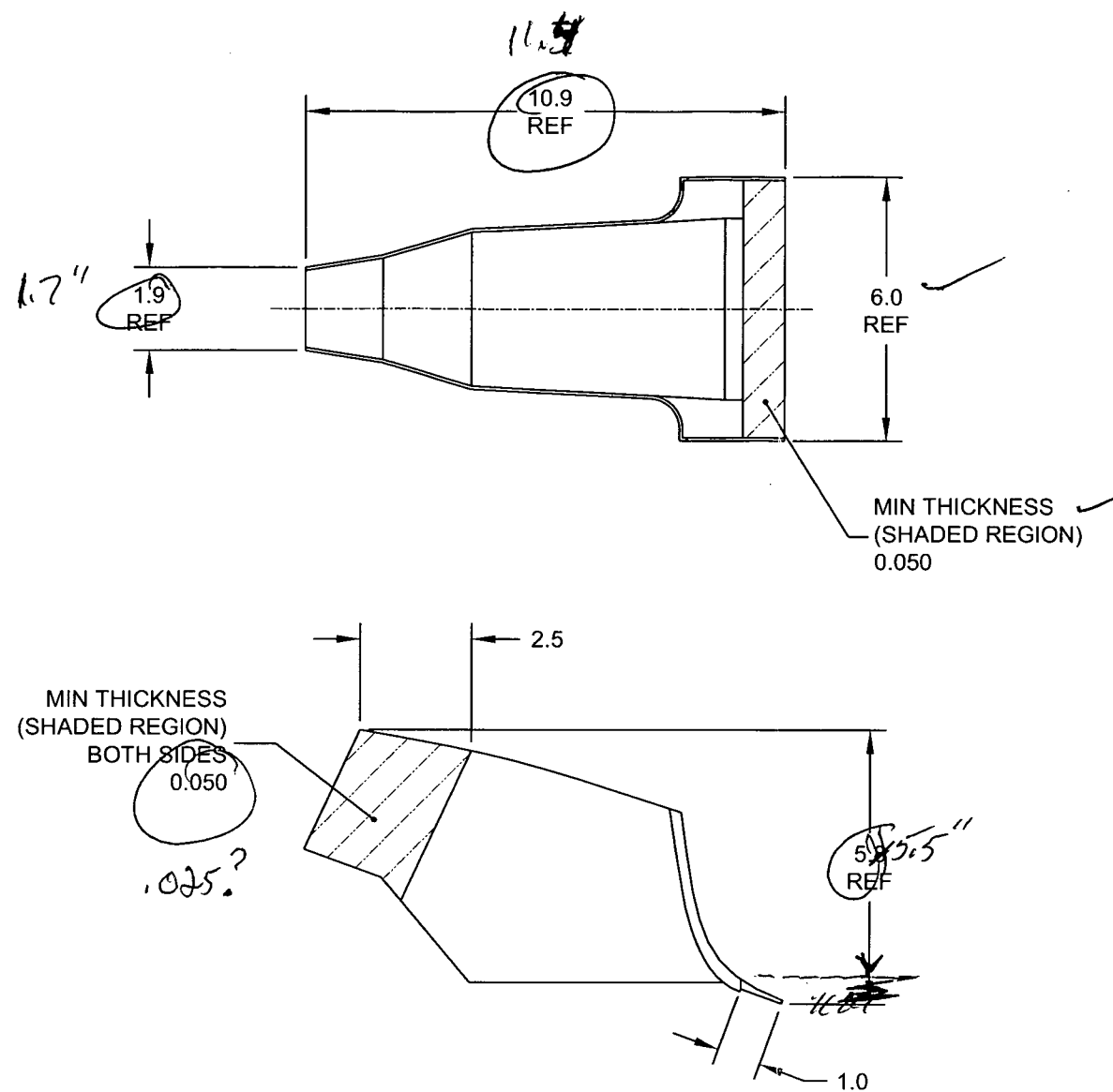
Measured by: BB Date: 09/07/16

### TRIMMING SECTION

| Drawing Dimension | Tolerance  | Actual Dimension | Accept | Reject | Method of Inspection | Comments |
|-------------------|------------|------------------|--------|--------|----------------------|----------|
| 1.0               | $\pm .100$ | 1.0"             | ✓      |        |                      |          |
| 6.0               | Ref        | 6.0"             | ✓      |        |                      |          |
| 11.4              | Ref        | 11.4"            | ✓      |        |                      |          |
| 0.050"            | MIN        | 0.061"           | ✓      |        |                      |          |
| 0.025"            | MIN        | 0.030"           | ✓      |        |                      |          |
|                   |            |                  |        |        |                      |          |
|                   |            |                  |        |        |                      |          |
|                   |            |                  |        |        |                      |          |
|                   |            |                  |        |        |                      |          |
|                   |            |                  |        |        |                      |          |

Measured by: Whelan Date: 09/07/15  
 Audited by: KA Date: 09.07.17  
 Prototype Approval: CU Date: 09.07.17

| Rev | Date | Change    | Revised by | Approved |
|-----|------|-----------|------------|----------|
| A   |      | New Issue | KJ/DL      |          |



**D3958-1 PANEL**

**PROTOTYPE**  
PLEASE RETURN ALL ISSUED  
DATA TO ENGINEERING  
09.07.03 *PH*

**NOTES:**

- 1) MATERIAL: SEE TABLE
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N (SEE TABLE) USING VIBRATING STYLUS
- 7) WEIGHT: 0.3 lbs
- 8) TOOLING: THERMOFORM PER MOLD DT9318 PER DART QSI 022. TRIM PER MOLD.
- 9) MINIMUM THICKNESS: 0.060" UNLESS OTHERWISE NOTED

| PART NUMBER | DESCRIPTION  |
|-------------|--|
| D3958-1KIV  | KYDEX 6185, 0.080 THICK, P3-VELOUR MATTE, IVORY #62015 (MKYD6185S.080-P3-62015)      |
| D3958-1KGY  | KYDEX 6185, 0.080 THICK, P3-VELOUR MATTE, STEEL GRAY #52068 (MKYD6185S.080-P3-52068) |

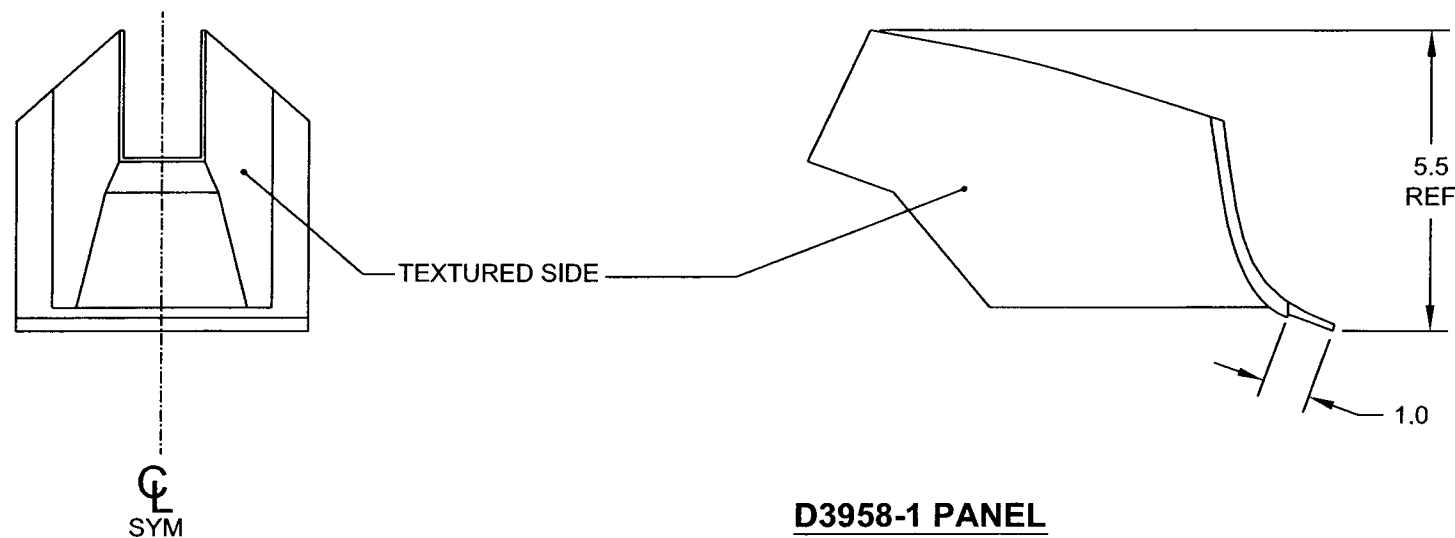
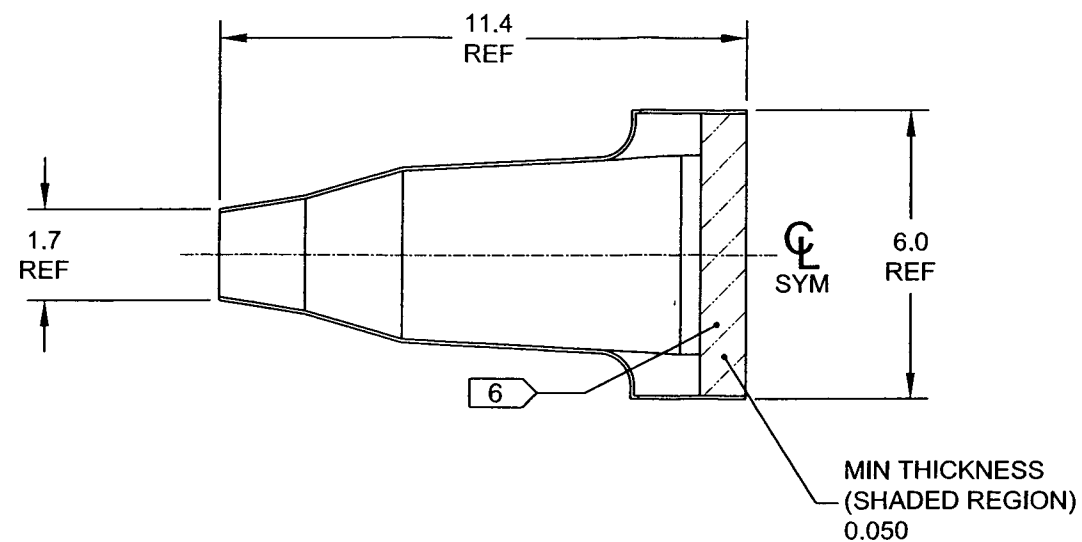
|            |             |  |              |
|------------|-------------|--|--------------|
| A          | NEW ISSUE   | PH   | 09.06.16     |
| REV.       | DESCRIPTION | BY   | DATE         |
| DESIGN     |             | <b>DART AEROSPACE LTD</b><br>HAWKESBURY, ONTARIO, CANADA   |              |
| DRAWN      |             |  |              |
| CHECKED    |             | DRAWING NO.  | REV. A       |
| MFG. APPR. |             | D3958  | SHEET 1 OF 1 |
| APPROVED   |             | TITLE  | SCALE        |
| DE APPR.   |             | PANEL (206 L3/L4)  | NTS          |
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D

C

B

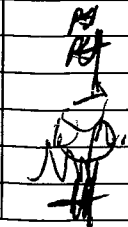
A



**NOTES:**

- 1) MATERIAL: SEE TABLE
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N (SEE TABLE) USING VIBRATING STYLUS
- 7) WEIGHT: 0.3 lbs
- 8) TOOLING: THERMOFORM PER MOLD DT9313 PER DART QSI 022. TRIM PER MOLD.
- 9) MINIMUM THICKNESS: 0.025" UNLESS OTHERWISE NOTED

| PART NUMBER | DESCRIPTION  |
|-------------|--|
| D3958-1KIV  | KYDEX 6185, 0.080 THICK, P3-VELOUR MATTE, IVORY #62015 (MKYD6185S.080-P3-62015)      |
| D3958-1KGY  | KYDEX 6185, 0.080 THICK, P3-VELOUR MATTE, STEEL GRAY #52068 (MKYD6185S.080-P3-52068) |

|  |   |  |              |
|--|---|--|--------------|
| A  | NEW ISSUE   | PH                                     | 09.06.16     |
| REV.   | DESCRIPTION   | BY                                     | DATE         |
| DESIGN   |  | DART AEROSPACE LTD                     |              |
| DRAWN  |   | HAWKESBURY, ONTARIO, CANADA            |              |
| CHECKED  |   | DRAWING NO.                            | REV. A       |
| MFG. APPR.   |   | D3958                                  | SHEET 1 OF 1 |
| APPROVED   |   | TITLE                                  | SCALE        |
| DE APPR.   |   | PANEL (206 L3/L4)                      | NTS          |
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